

Date: Wednesday, 3/14/2007 12:25:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 31194	
Estimate Number : 10437	
P.O. Number : <u>N/A</u>	Part Number : D33191
This Issue : 3/14/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30904	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 3/30/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC	
Est Rev:C Now on Waterjet 06-10-26 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010S18GA

1010/1025/A21/6aA SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 5.2752 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: M103676 (6)M10287 (2)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: BProg Rev: B

SAD 07/05/09 (8)

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/09 (8)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SAD 07.05.09

8

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 07/05/09 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:36 PM
User: Kim Johnston

Process Sheet

slip 23-24/05

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31194

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SB 07/05/16

(8)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

070516 (8)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: D

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

103551

FC 07 05 22

(8)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/23 (8)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07-05-24 (8)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/24 (8)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18 and Stock.

Location: ST 342

07/05/24 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31194

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

207K5124

Job Completion



207-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. B

SHEET 1 OF 5

SCALE

WEARPLATE

1:8

A	
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04.09.24

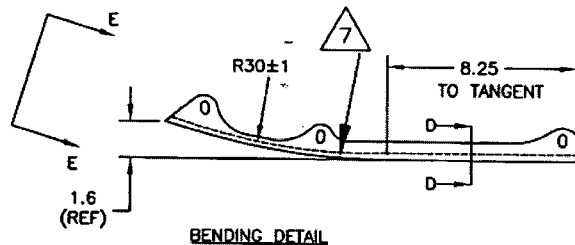
NEW ISSUE

1

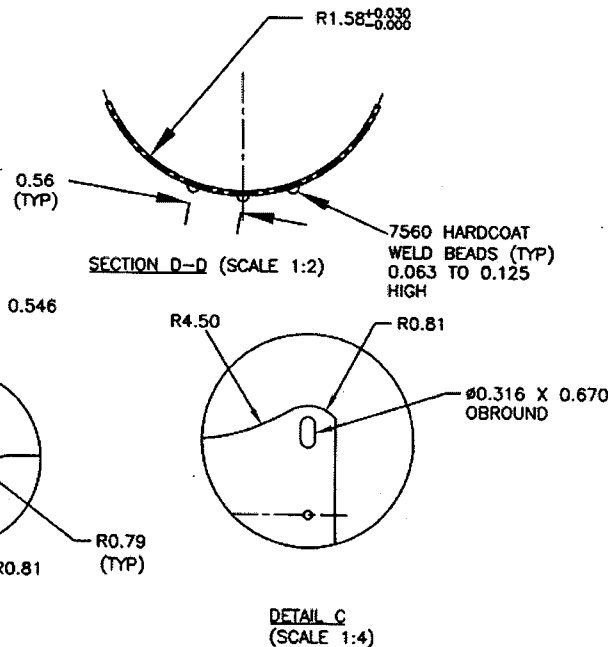
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05.06.06

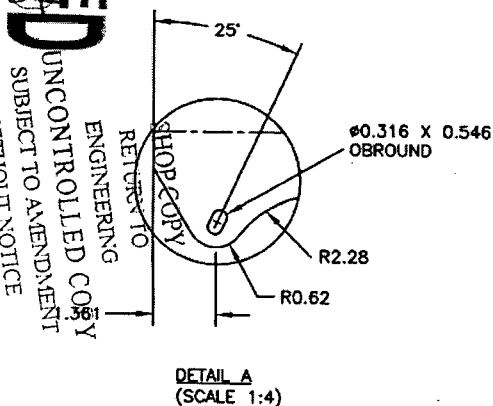
WIDEN HOLES, REDUCE WIDTH -3/-5/-7



BENDING DETAIL



DETAIL C
(SCALE 1:4)



DETAIL A
(SCALE 1:4)

DETAIL B
(SCALE 1:4)

D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-09-30

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NOTICE

WORK ORDER
5192

NO

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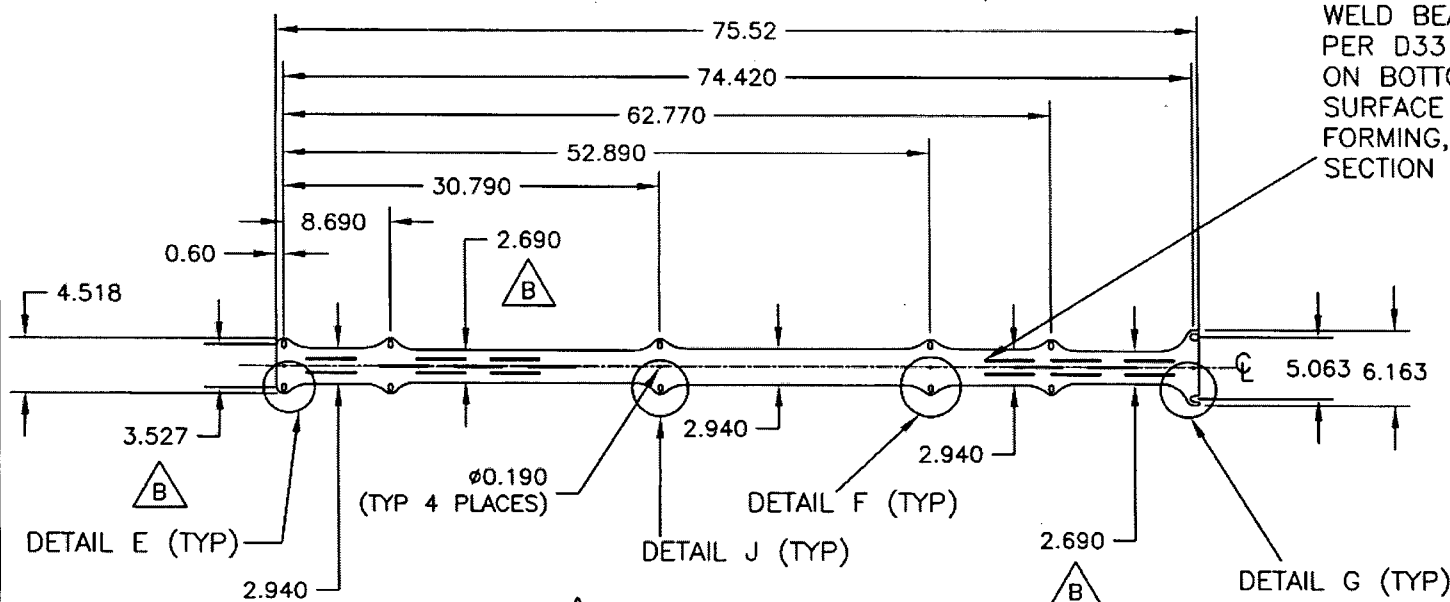
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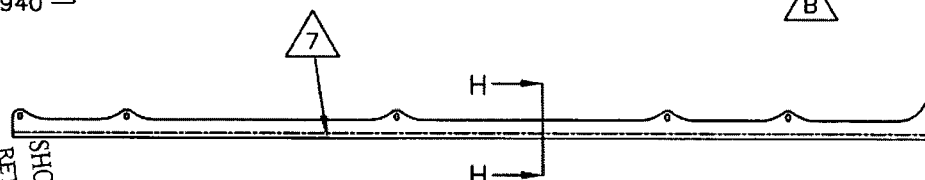
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

FLAT PATTERN



BENDING DETAIL





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WORK ORDER
NO. 31194

D3319-3 WEARPLATE

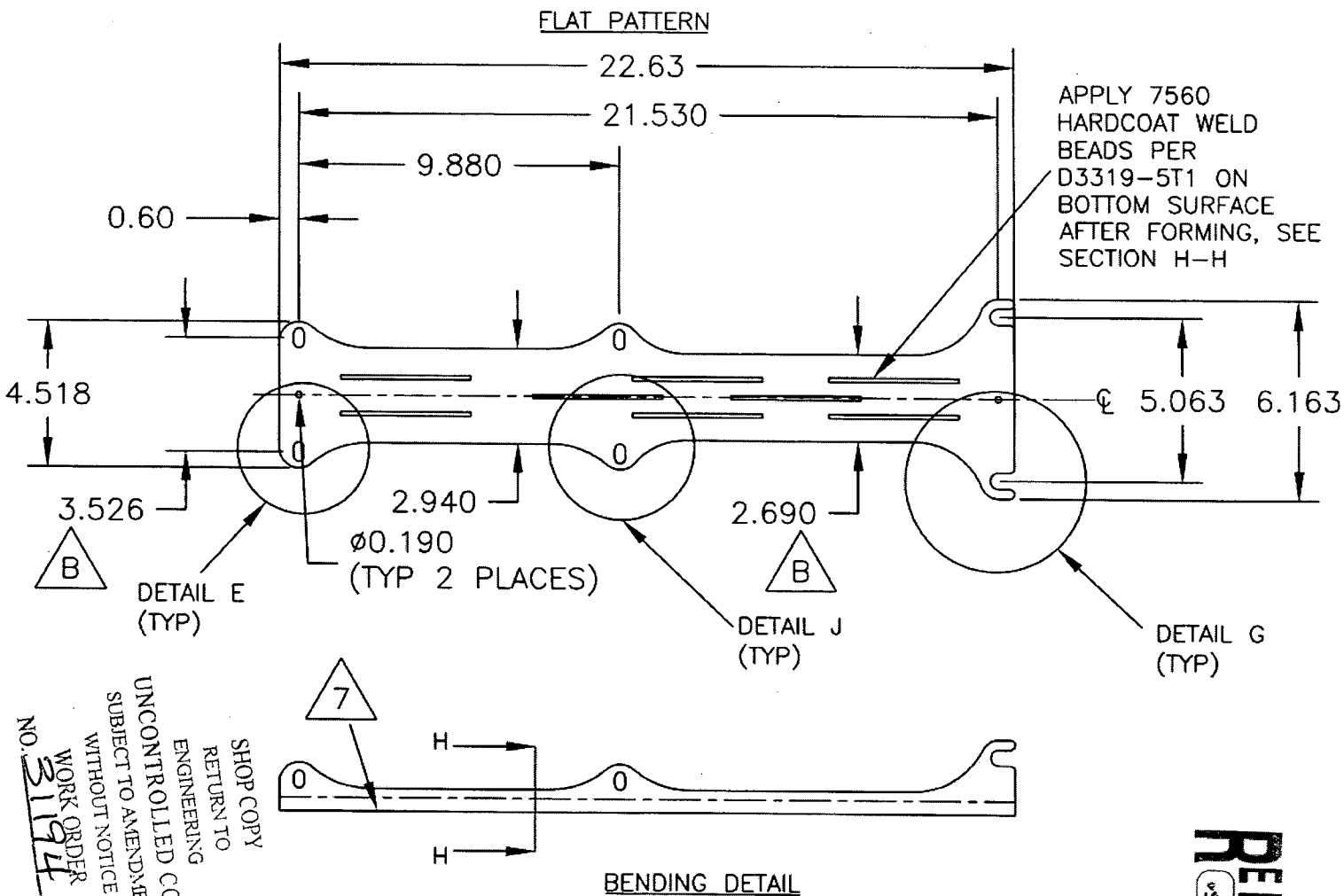
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
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DATE	05.06.06			TITLE	WEARPLATE
				REV. B	SHEET 3 OF 5
				SCALE	1:5

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05-09-30



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
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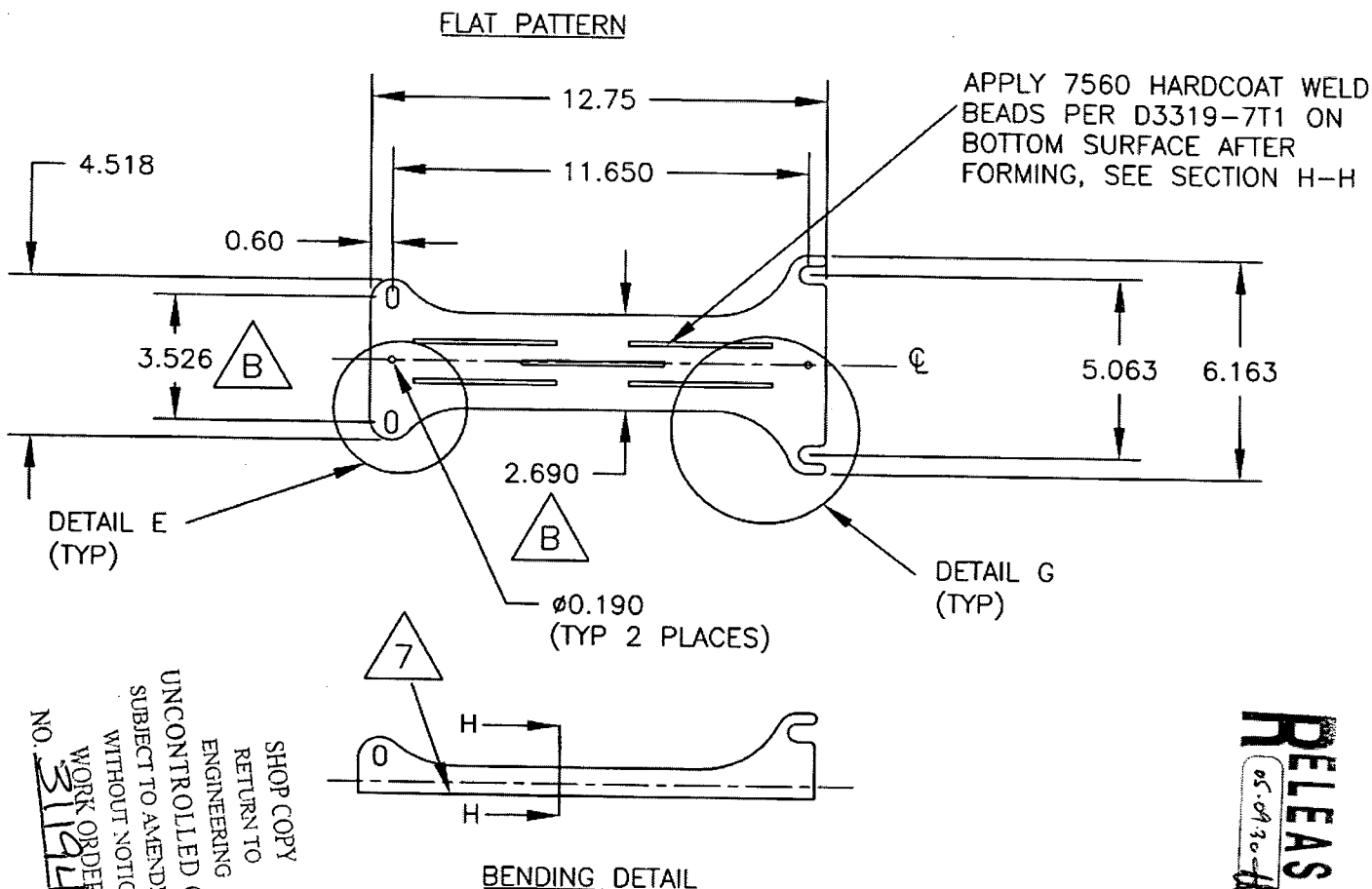
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DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

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D3319-7 WEARPLATE

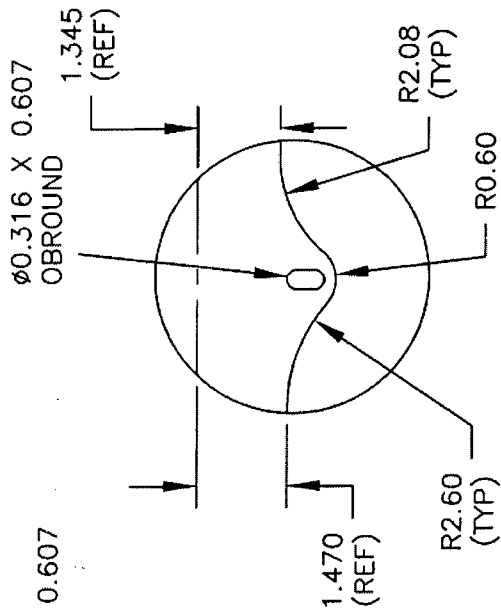
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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NO. 31194

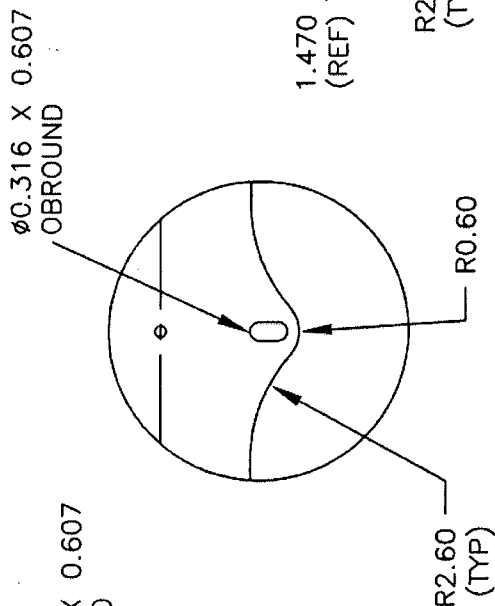


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

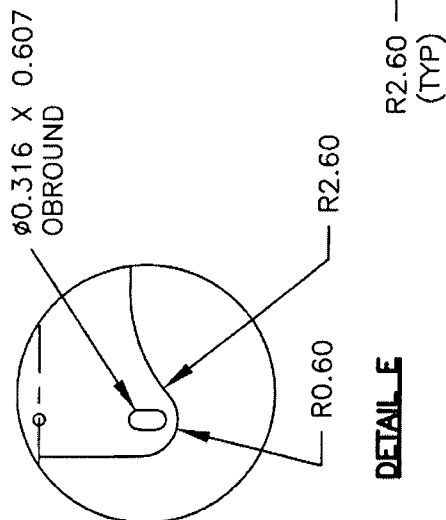
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05-09-30



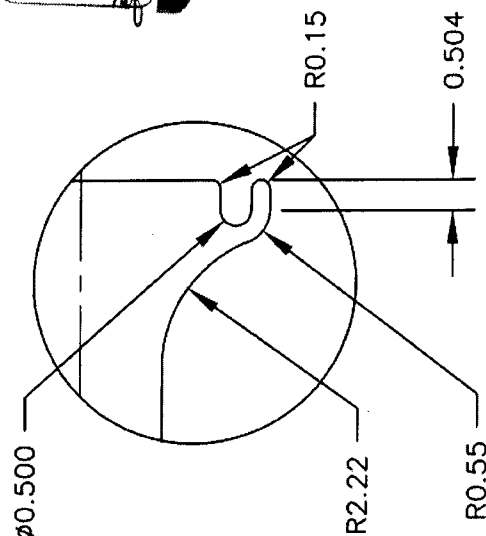
DETAIL J



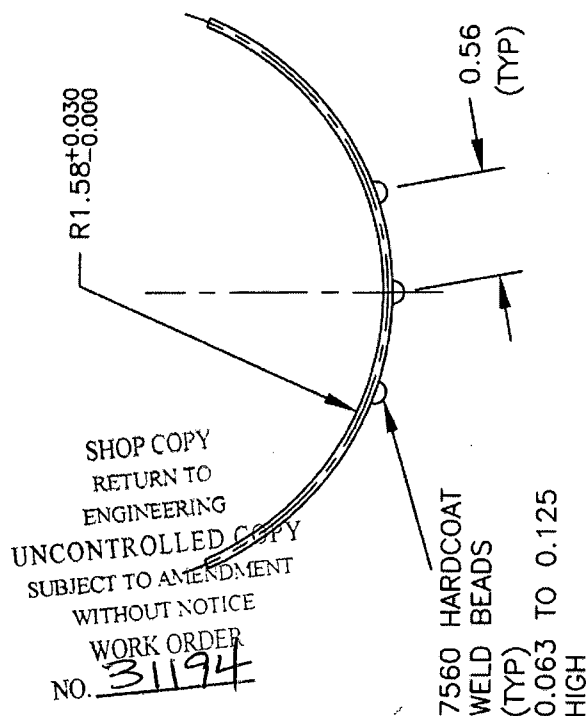
DETAIL F



DETAIL E



DETAIL G



**SECTION H-H
(SCALE 1:1)**

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DART AEROSPACE LTD		Work Order: 31194
Description: WEARPLATE		Part Number: D33191
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.984	± 0.010	4.982	✓		Vern	
B 3.815	± 0.010					
C 1.600	± 0.010	1.608	✓		Vern	
D 2.660	± 0.010	2.669	✓		Vern	
E 3.190	± 0.010	3.199	✓		Vern	
F 3.563	± 0.010	3.558	✓		Vern	
G 4.712	± 0.010	4.712	✓		Vern	
H 0.60	± 0.030	0.61	✓		Vern	
I 10.576	± 0.010	10.571	✓		Vern	
J 11.942	± 0.010	11.949	✓		Vern	
K 16.100	± 0.010	16.100				
L 18.09	± 0.030	18.09	✓		Vern/M-T	
M $\varnothing 0.316 \times 0.546$	± 0.010	0.311×0.544	✓		Vern	
N $\varnothing 0.316 \times 0.670$	± 0.010	0.310×0.672	✓		Vern	
O $\varnothing 0.190$	± 0.005 ± 0.001	$\varnothing 0.190$	✓		Vern	
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAG	Audited by:	Prototype Approval: PH N/A
Date: 07/05/09	Date: 07-05-09	Date: 07-05-09

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	